

Work Order ID 59668

Wednesday, June 09, 2010 12:33:28 PM



Page 1

Item ID: D3688-1

Accept



Setup

Start



Revision ID:

Item Name: STUD

Stop



Start Date: 6/9/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 7/2/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: 11

Date: 10-6-09 Tooling: _____ Date: _____

Run

Start



QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3688

Rev B C

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

DO NOT USE CHOP SAW

Cut blank 11.673" long

SL 10/06/23



110

0.00



DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Folio FA718 Rev: N/A & Dwg D3688 Rev: C 2-Deburr
per dwg D3688

3-Check .625" bore with DT9530 GO/NO GO Gauge

SL 10/06/23 (6)

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 10/06/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-07-05 W/O Dug Weller		dwg is now @ Rev C. update loo. perm change		10-07-05		✓ 1007-05	✓ 10-07-05
10-07-05 130 ↓ 160		additional c: repeated steps. remove from F.PP. perm change		10-07-05		✓ 1007-05	✓ 10-07-05

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Start Date: 6/9/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 7/2/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run

Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

130



Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Lathe Conv

CONVENTIONAL LATHE

0.00

Conventional Lathe

Memo

0.00

Face to finished length as per dwg D3688 AND center drill as per Dwg D3688

140



QC

Quality Control

QC2- Inspect parts off machine FA1/FA1B

0.00

Memo

0.00

150



Doosan

Doosan Lathe

DOOSAN LATHE

0.00

Memo

0.00

1- Turn as per Folio FA718 Rev: _____ & Dwg D3688 Rev: _____ 2-Deburr
per dwg D3688

W/O:		WORK ORDER CHANGES						
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Page 3

Item ID: D3688-1

Accept



Setup

Start



Revision ID:

Item Name: STUD

Start Date: 6/9/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 7/2/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run

Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

~~QC2- Inspect parts off machine FAI/FAIB~~

0.00

170



QC

Quality Control

QC8- Inspect parts - second check

0.00

88
10/06/28

6

0

180



Purchasing

Purchasing

PURCHASING

0.00

Memo

0.00

Issue P/O: 12200

LPI Per ASTM 1417 LEVEL

Certificate of conformaty is required

CZ 10/7/11

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Wednesday, June 09, 2010 12:33:28 PM



Page 4

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Accept



Setup

Start



Revision ID:

Item Name: STUD

Start Date: 6/9/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 7/2/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Packaging

Memo

0.00

Ensure certificate of conformity is attached

200



QC

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

210



Packaging

Identify as per dwg & Stock Location: C70

0.00

Packaging

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 5

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Cust Item ID:

Required Date: 7/2/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:
	QC:	Date:	SPC (Y/N):	Date:

Run

Start



Stop

Sequence ID/
Work Center ID

220

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
StampQC
Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, June 09, 2010 12:33:32 PM

Page 1

Work Order ID: 59668



Parent Item: D3688-1



Parent Item Name: STUD

Start Date: 6/9/2010

Required Date: 7/2/2010

Comments: IPP Rev:A New Issue 08-01-29 JLM Verified By:EC
IPP Rev:B Material Change 09-01-07 JLM Verified By:EC
IPP Rev:C Added note on Step 2 09-01-26 JLM Verified By:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ M174PH-H900R1.000	Replacement	Mfg/ Purchased	Bin No	Primary	Last	Route 100	Unit of f	Qty on 63.1000	Qty per Kit 1.087	Total 6.865263	Qty	Date	Status
17-4SS H900 ROUND BAR 1.00													

Location	Loc Qty	Loc Code
MAT030	63.1	
112374	1.5	
112570	61.6	

5.9

SL 10/06/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	59668
Description: Stud	Part Number:	D3688-1
Inspection Dwg: D3688 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.695	+/-0.010	.695	✓			
0.625	+0.004/-0.000	.627	✓			
1.25	+0.000/-0.03	1.230	✓			
118°	0.5°	118°	✓			
R0.03	+/-0.030	.030	✓			
0.11 Ref	+/-0.030	.11	✓			
90°	0.5°	90°	✓			
Ø0.189	+0.005/-0.001	.191	✓			
1.31	+/-0.030	1.300	✓			
1.65	+/-0.030	1.650	✓			
0.870	+0.000/-0.010	.865	✓			
Ø0.659	+0.000/-0.015	.647	✓			
11.573	+/-0.015	11.575	✓			
2.90	+/-0.030	2.905	✓			
3/4-16UNF-2A	N/A		✓			
0.075 x 45°	+/-0.010 x 0.5°	.08x45°	✓			
0.370	+0.000/-0.010	.365	✓			
Ø0.189	+0.005/-0.001	.191	✓			
R0.25	+/-0.030	.25	✓			
R0.50	+/-0.030	.50	✓			

Measured by:	S	Audited by:	BF	Prototype Approval:	N/A
Date:	18/06/26	Date:	10/06/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	
B	09.11.04	Dwg Rev updated	KJ	M

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SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED CO

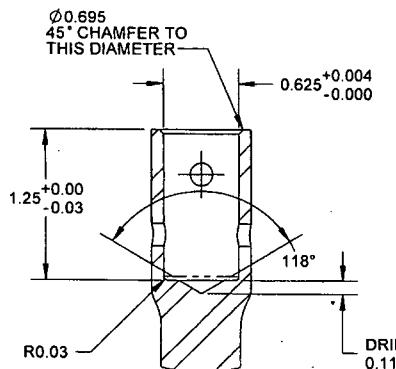
SUBJECT TO REVISIONS

WITHOUT NOTICE

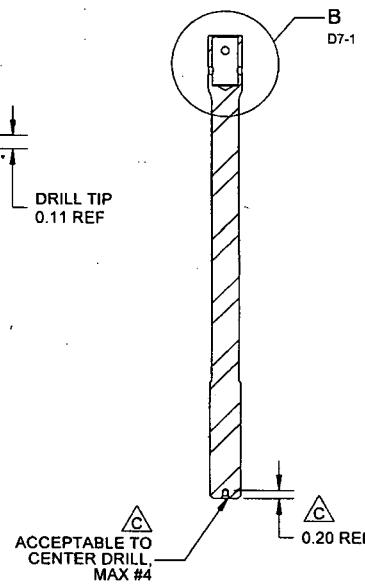
WORK ORDER

NO. 59468

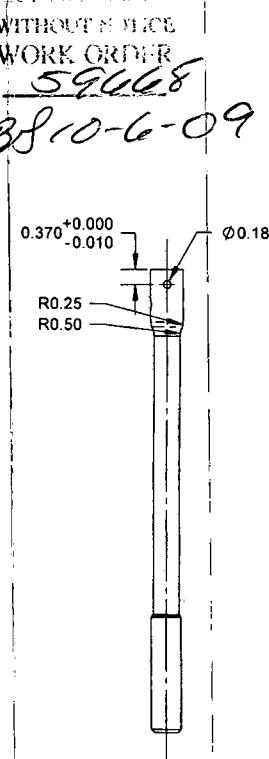
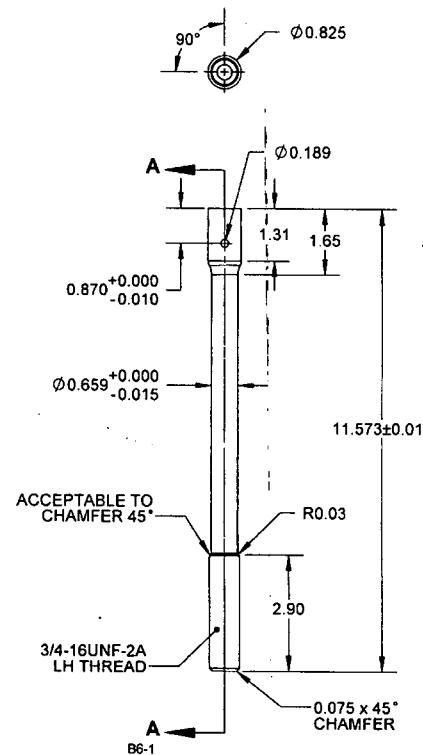
3810-6-09



DETAIL B
SCALE 3X
D6-1



SECTION A-A
D4-1



RELEASED
2009-09-22
MM

- NOTES:**
- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 1.24 lb
 - 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

D3688-1 STUD

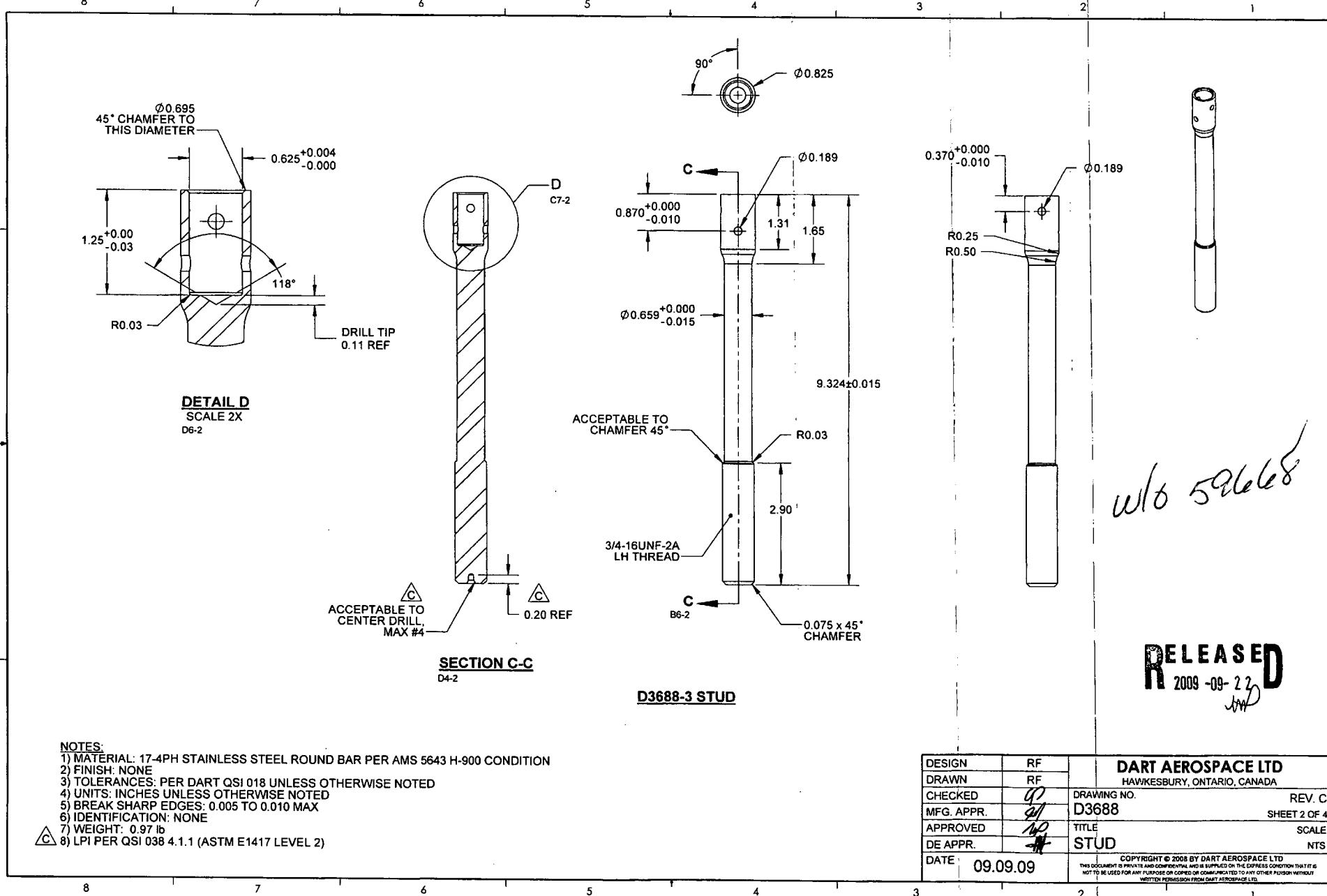
C	0.20 WAS 0.16 (ZN B5-1, B5-2, B6-3, B5-4); CENTER DRILL #4 WAS CENTER DRILL #2 (ZN B5-1, B6-2, B6-3, B6-4); UPDATE NOTE 6 TO REF. QSI (ZN A8-1, A8-2, A8-3, A8-4)	RF	09.09.09
B	CHANGE TO 17-4PH H-900 (ZN A8-1, A8-2, A8-3, A4-4); REFORMATTED TO CURRENT DWG STANDARDS FROM 12.073 TO 11.573 (ZN C2-1) BASED ON PROTOTYPING. 0.075 WAS $\phi 0.665$ (ZN D8-1, D8-2, D8-3). $\phi 0.508$ WAS $\phi 0.478$ (ZN D8-4); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKSLEY, ONTARIO, CANADA	
CHECKED	PP	DRAWING NO.	REV. C
MFG. APPR.	SD	D3688	SHEET 1 OF 4
APPROVED	NP	TITLE	SCALE
DE APPR.	HP	STUD	NTS
DATE	09.09.09	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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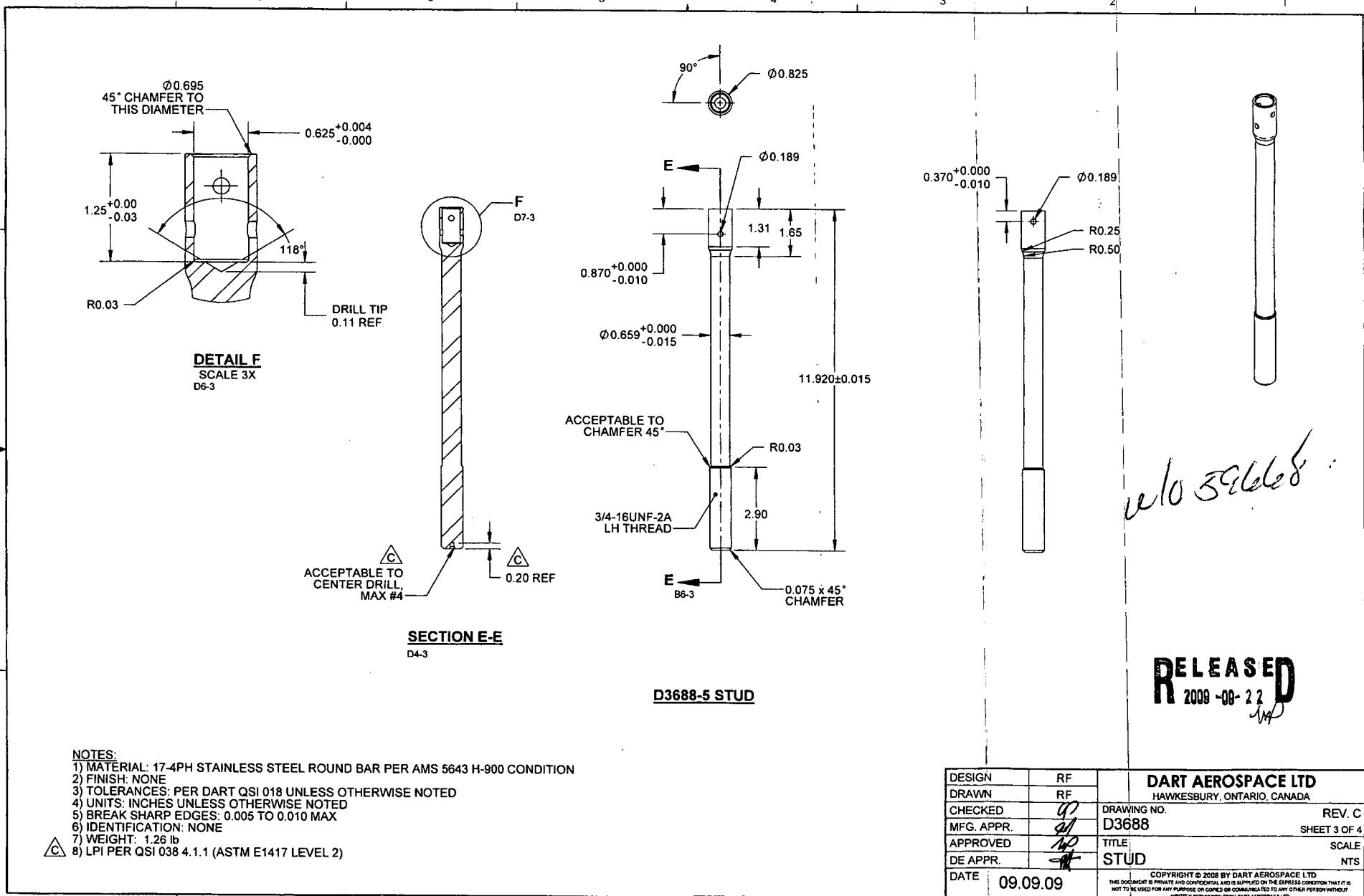


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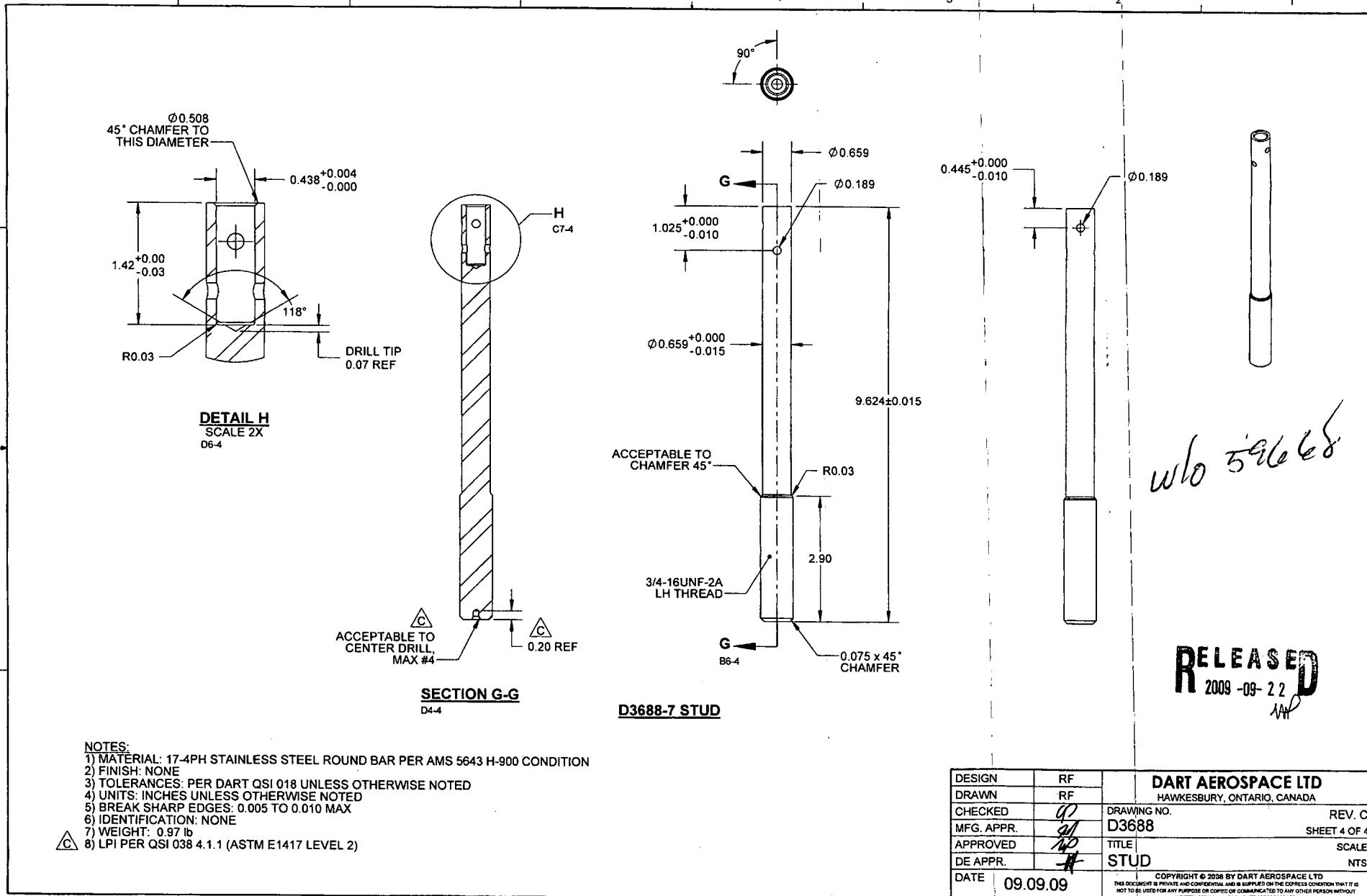


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DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GD	DRAWING NO.	REV. C
MFG. APPR.	SD	D3688	SHEET 4 OF 4
APPROVED	AD	TITLE	SCALE
DE APPR.	H	STUD	NTS
DATE	09.09.09		

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LIQUID PENETRANT TEST REPORT

P- 15329

CLIENT	<u>DALT Aerospace</u>	DATE	<u>JULY 2-2010</u>	PAGE	<u>1</u>	OF	<u>1</u>
ATTENTION	<u>LINDA / CHANTEL</u>	TIME	<u>AM</u>	AM	<input checked="" type="checkbox"/>	PM	<input type="checkbox"/>
ADDRESS	<u>1270 ABERDEEN ST.</u>	ACUREN JOB NO.	<u>188-10-C776</u>				
	<u>HAWKES BAY, ON.</u>	PO/WO NO.	<u>1122001</u>				
PROJECT	<u>K6H 1K7</u>	WORK LOCATION	<u>MAIN SHOp - HAWKES Bay</u>				
ITEM(S) EXAMINED	<u>F.P.I. on CROSS TUBES & MACHINED PARTS</u>	ACCEPTANCE STD.	<u>ASTM 1417</u>	REV./DATE	<u>2007</u>		
	<u>Four CROSS TUBES</u>						
	<u>ELEVEN MACHINED STUDS.</u>						

JOB DESCRIPTION	PROCEDURE NO. LT0002 REV./DATE	TECHNIQUE NO. LTTEST2 REV./DATE
PART NO.	<u>-</u>	MATERIAL <u>S. STEEL</u> THICKNESS <u>ALUMINUM</u> - <u>ALUMINUM</u>
SCOPE	<u>WET FLUORESCENT LIQUID PENETRANT</u>	<u>INSPECTION CARRIED OUT 100% EXTERNAL.</u>

TEST DETAILS							
METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED		
FAMILY BRAND	<u>MAGNAFLUX</u>		BLACK LIGHT S/N <u>16454</u>	<input type="checkbox"/> OUTPUT > 1000 μ W/cm ²	<input type="checkbox"/> AMBIENT < 2 fc		
PENETRANT	<u>ZL67</u>	MINIMUM Dwell TIME <u>4510</u> MIN.	LIGHTING EQUIP. <input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT	<input type="checkbox"/> OUTPUT > 100 fc @ SURFACE			
PENETRANT REMOVER	<u>H2O</u>	MINIMUM DRY TIME <u>>10</u> MIN.	OTHER <u>LABINO</u>				
DEVELOPER	<u>SKD 52</u>	MINIMUM Dwell TIME <u>10</u> MIN.	LIGHT METER S/N <u>1098866</u>	CAL DUE DATE <u>OCT. 19</u>			
DEVELOPER TYPE	<input type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY	<u>2010</u>			

TEST SURFACE							
SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input checked="" type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input checked="" type="checkbox"/> CLEAN BARE METAL		
SURFACE TEMPERATURE	<u>< - 4°C/ 20°F</u>		<u>- 4°C/ 20°F to 10°C/50°F</u>		<input checked="" type="checkbox"/> 10°C/50°F to 52°C/125°F	<input type="checkbox"/> > 52°C/125°F	

RESULTS - (<input type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL)							
<p><u>6 - STUDS - W.O. 59668</u></p> <p><u>5 - STUDS - W.O. 58635</u> ✓</p> <p><u>1 - CROSS TUBE - W.O. 59975</u> ✓</p> <p><u>1 - CROSS TUBE - W.O. 59976</u> ✓</p> <p><u>1 - CROSS TUBE - W.O. 58387</u> ✓</p> <p><u>1 - CROSS TUBE - W.O. 58388</u> ✓</p> <p><u>INDICATIONS on CROSS TUBES.</u> <u>W.O. # 59975</u> <u>W.O. # 59976</u> <u>W.O. # 58388</u> <u>IN PROCESS TO BE REVIEWED</u></p> <p><u>10 07 03</u></p>							

Scope of Services							
<p>The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.</p>							

Standard of Care							
<p>In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.</p>							

SIGNATURES							
CLIENT REPRESENTATIVE	<u>JASON Murdoch</u>	PRINT	<u>J. Murdoch</u>	SIGNATURE	DTR #	<u>E63366</u>	
TECHNICIAN (SIGNATURE):	<u>Mike Huston</u>				REPORT		
NAME (PRINT):	<u>Mike Huston</u>	1 ST TECHNICIAN	2 ND TECHNICIAN	REVIEWED BY:	NAME	INITIALS	
CGSB LEVEL	<u>S</u>	SNT LEVEL	CGSB LEVEL	SNT LEVEL			
CGSB REG. NO.	<u>6606</u>		CGSB REG. NO.				

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY